



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3041-1
Job Sheet 205634



Part No: D3041-1

Job Qty: 25 pcs

Part Name: Clamp



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/15/20

Job Tracking No:

Due Date: 4/10/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP RevA: as per revC1 DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
10	Purchasing	25 pcs		4/9/20	0.00 0.00			
20	Packaging 2-1 - Receive - B4B	25 pcs		4/9/20	0.00 0.00	Packaging 2 - 1 - B4B		APR 16 2020
						Packaging 2 - 2 - B4B		
						Packaging 2 - 3 - B4B		
						Packaging 2 - 5 - B4B		APR 16 2020
						Packaging 2 - 4 - B4B		
						Packaging 2 - 6 - B4B		
						Packaging 2 - 7 - B4B		
						Packaging 2 - 8 - B4B		
						Packaging 2 - 9 - B4B		
						Packaging 2 - 10 - B4B		
						Packaging 2 - 11 - B4B		
						Packaging 2 - 12 - B4B		
						Packaging 2 - 13 - B4B		
						Packaging 2 - 14 - B4B		
						Packaging 2 - 15 - B4B		
						Packaging 2 - 16 - B4B		
						Packaging 2 - 17 - B4B		
						Packaging 2 - 18 - B4B		
						Packaging 2 - 19 - B4B		
						Packaging 2 - 20 - B4B		
						Packaging 2 - 21 - B4B		
						Packaging 2 - 22 - B4B		
						Packaging 2 - 23 - B4B		
						Packaging 2 - 24 - B4B		
						Packaging 2 - 25 - B4B		
						Packaging 2 - 26 - B4B		
						Packaging 2 - 37 - B4B		
30	QC 6	25 pcs		4/9/20	0.00 0.00	QC 6 - 9		
						QC 6 - 68		



Container No: S271007



Part: D3041-1

Job No: 205634

Serial No/Batch: S271007

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 04/16/20

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				QC 6 - 61	DAS
				QC 6 - 40	APR 7 11 2020 40
				QC 6 - 81	9-89
131 Handfinish - 1-1 Chemical-B4B	25 pcs	4/9/20	0.00 0.83	Handfinish - 1 - 1 - B4B	BEB 20-04-24
132 QC 7	25 pcs	4/9/20	0.00 0.00	QC 7 - 10	20-04-28
133 Powdercoat - 1 White GI(A)-B4B	25 pcs	4/9/20	0.00 0.42	Powdercoat - 1 - B4B	20-04-28
134 QC 3	25 pcs	4/9/20	0.00 0.00	QC 3 - 10	20-4-29
135 Small Fab - 2 - B4B	25 pcs	4/10/20	0.00 1.86	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	MAY 08 2020
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
				Small Fab - 9 - B4B	
				Small Fab - Various 1 - B4B	
145 QC 5	25 pcs	4/10/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	MAY 08 2020
				QC 5 - 61	
				QC 5 - 81	
180 Packaging 3-1 - Stock - B4B	25 pcs	4/10/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	DAS
				Packaging 3 - 5 - B4B	28
				Packaging 3 - 6 - B4B	9-89
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	20-05-11
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	

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				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 37 - B4B	
190 QC 21 - SA	25	4/10/20	0.00 0.00	QC 21 - SA - 21	21 20-05-11
	pcs			QC 21 - SA - 70	8-05
				QC 21 - SA - 53	

Part Op 110 - Outsource process - Machining Issue P/O to Metec :POHB045579 Machine, ALODINE, POWDER COAT as per Descriptions: dwg C of C is required ATTN: MASK BEARING HOLE, PRIOR TO POWDER COATING

120 - Receive & Inspect for Damage & Mat'l Certs Ensure C of C is attach

130 - QC6- All purchased or subcontracted products

131 - Chemical Conversion Coat per QSI005 4.1

132 - QC7-Inspect Chemical Conversion Coat

133 - START TIME: 2:45 OVEN TEMPERATURE: 320° FINISH TIME: 1:15.

134 - QC3- Inspect Part Finish Standard Process

135 - Small Fab Memo 1- Press 02611 bearing into lug as per Dwg 03041 using OT 9472 2- Stake bearing into place as per Dwg D3041 using DT9456 3-Touch up stake marks with white imron paint

145 - QC5- Inspect part completeness to step on W/O

180 - Identify as per dwg & Stock Location:

190 - QC21- Final Inspection - Work Order Release

Patrick Lussier

PO Details

Metec Metal Technology Inc. (mem001-vc)



PO No: POHB045579

Line No: 1

Job BOM

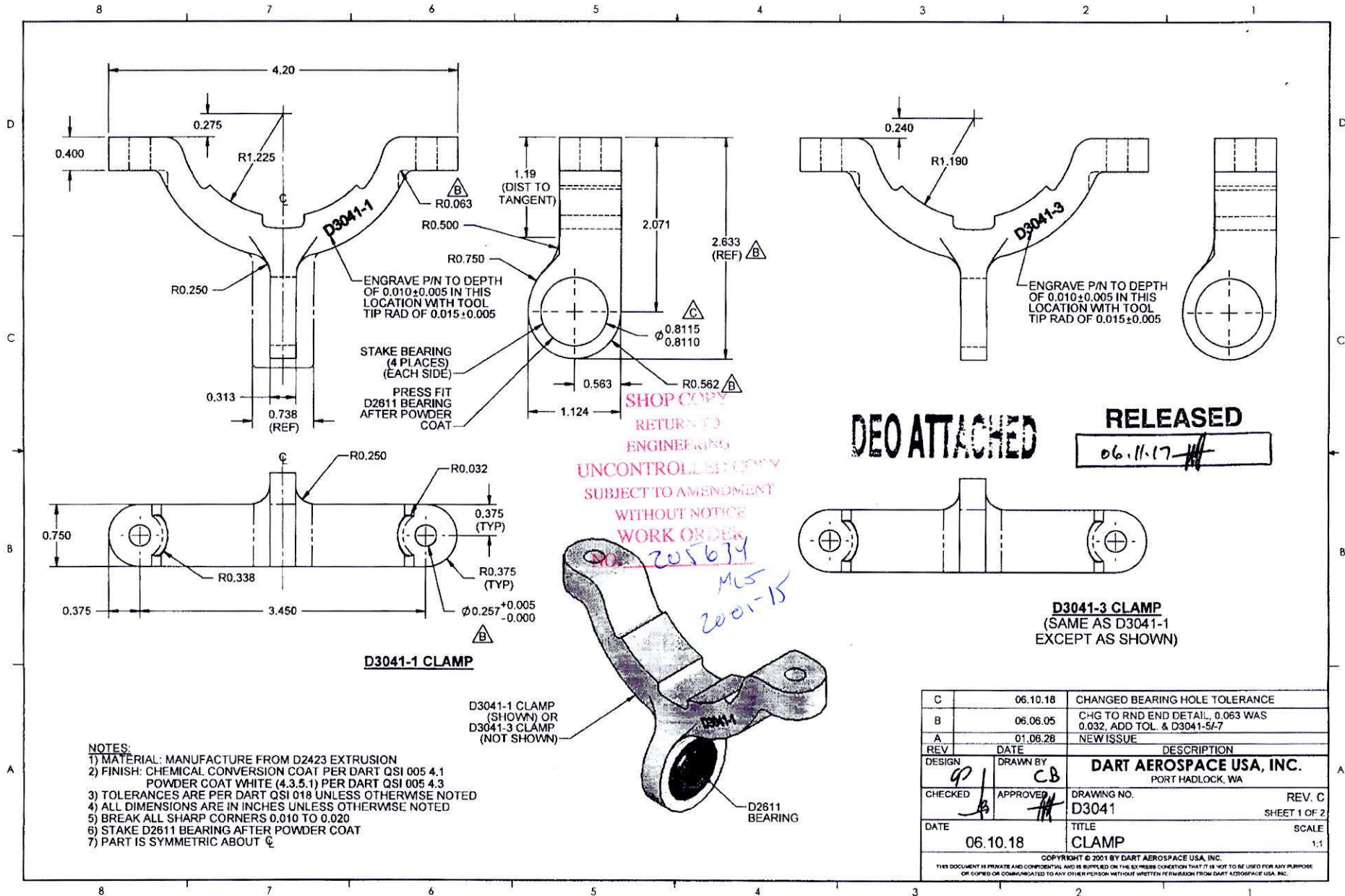
Part / Item	Component Name	Quantity	Operation	Container
D2423	Lug Extrusion	2.0825 ft (.0833 ea)	110-Purchasing	
D2611	Bearing	25 pcs (1 ea)	135-Small Fab - 2 - B4B	5266578
D3041-1P	Clamp	25 pcs (1 ea)	135-Small Fab - 2 - B4B	5271004

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Purchasing	D2423	2	539	0
135-Small Fab - 2 - B4B	D2611	25	258	0
	D3041-1P	25	0	0

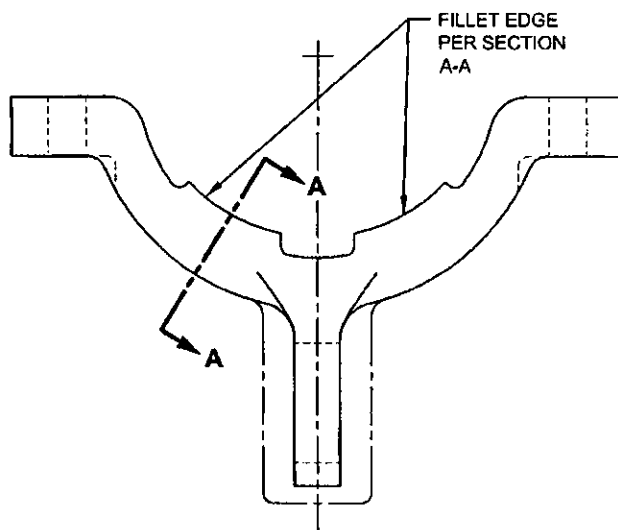
Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Clamp	4.200Inches $\pm$ 0.030	4.230 4.170		
2	Clamp	0.275Inches $\pm$ 0.010	0.285 0.265		
3	Clamp	1.225Inches $\pm$ 0.010	1.235 1.215	Radius	
4	Clamp	0.400Inches $\pm$ 0.010	0.410 0.390		
5	Clamp	0.250Inches $\pm$ 0.010	0.260 0.240	Radius	
6	Clamp	0.313Inches $\pm$ 0.010	0.323 0.303		
7	Clamp	0.063Inches $\pm$ 0.010	0.073 0.053	Radius	
8	Clamp	1.190Inches $\pm$ 0.030	1.220 1.160		
9	Clamp	1.124Inches $\pm$ 0.010	1.134 1.114		
10	Clamp	0.563Inches $\pm$ 0.010	0.573 0.553		
11	Clamp	0.562Inches $\pm$ 0.010	0.572 0.552	Radius	
12	Clamp	0.812Inches + 0.000 - 0.001	0.812 0.811	Diameter	
13	Clamp	2.071Inches $\pm$ 0.010	2.081 2.061		
14	Clamp	0.750Inches $\pm$ 0.010	0.760 0.740		
15	Clamp	0.375Inches $\pm$ 0.010	0.385 0.365		
16	Clamp	0.338Inches $\pm$ 0.010	0.348 0.328	Radius	
17	Clamp	3.450Inches $\pm$ 0.010	3.460 3.440		
18	Clamp	0.257Inches + 0.005 - 0.000	0.262 0.257	Diameter	
19	Clamp	0.375Inches $\pm$ 0.010	0.385 0.365	Radius	
20	Clamp	0.375Inches $\pm$ 0.010	0.385 0.365		
21	Clamp	0.032Inches $\pm$ 0.010	0.042 0.022	Radius	
22	Clamp	0.250Inches $\pm$ 0.010	0.260 0.240	Radius	

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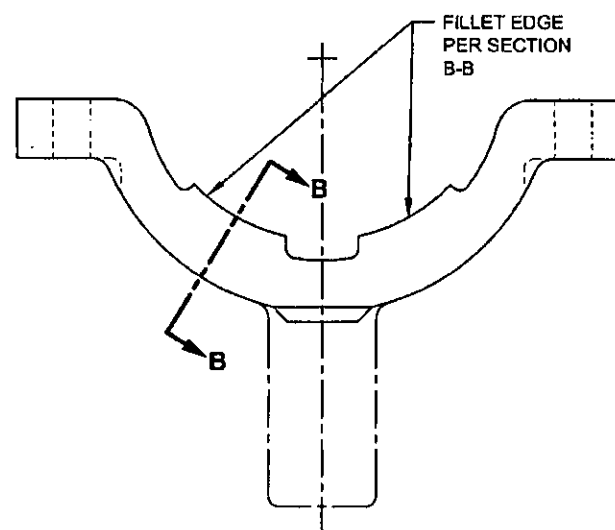
DRAWING NO. D3041	TITLE CLAMP	REV. C	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D3041-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN ADS	CHECKED	MFG. APPR.	APPROVED	DE APPR.		
DATE 09.03.04	DATE 09.03.12	DATE 09.03.12	DATE 09.03.13	DATE 09.03.13		

ADD FILLETS TO -1/-3/-5/-7 PER SECTIONS A-A AND B-B TO PREVENT CHAFING OF RUBBER CUSHIONS AS SHOWN:



D3041-1 CLAMP

D3041-3 CLAMP



D3041-5 CLAMP

D3041-7 CLAMP



R0.060 MIN - R0.10 MAX
2PL

SECTION A-A

SCALE 2X

SECTION B-B

SCALE 2X

SEE PAR 122 FOR FURTHER DETAILS

RELEASED
09/07/07 MBP

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NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

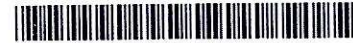
Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER POHB045579



Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045579

PO Date: 1/15/20

Due Date: 4/10/20

**Purchase Order
Revision:**

Revision Date:

Issued By: Lussier, Patrick
Phone: 613-632-5200 Ext: 276
plussier@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Items														
Line Item	Job	Part	Drawing	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	205634	D3041-1P	D3041 Rev.C			Clamp : Various STC's receive pcs	Firmed X25	-	4/10/20	25 Ea	0 Ea	25 Ea	\$14.41/Ea	\$360.25
Line Item Note *** UNPAINTED ***														
2	205635	D3041-3P	D3041 Rev.C			Clamp : Various STC's receive pcs	Firmed X25	-	4/10/20	25 Ea	0 Ea	25 Ea	\$14.41/Ea	\$360.25
Line Item Note *** UNPAINTED ***														
3	205636	D3041-5P	D3041 Rev.C			Clamp : Various STC's receive pcs	Firmed X25	-	4/10/20	25 Ea	0 Ea	25 Ea	\$15.75/Ea	\$393.75
Line Item Note *** UNPAINTED ***														
4	205637	D3041-7P	D3041 Rev.C			Clamp : Various STC's receive pcs	Firmed X25	-	4/10/20	25 Ea	0 Ea	25 Ea	\$15.75/Ea	\$393.75
Line Item Note *** UNPAINTED ***														
													Grand Total: \$1,508.00	

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9-89



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
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Tel (613) 632-5200

PURCHASE ORDER

POHB045579



Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

Patrick Lussier

A049 SUPPLIER AWARENESS

Plex 4/8/20 9:07 AM dart.lussier.patrick



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	Dwg Rev.#	Material Batch #	Paint Batch #	P.O. Number
25	DART-D3041- 1P- UNPAINTED	Clamp	C	S101247	-	HB045579
25	DART-D3041- 3P- UNPAINTED	Clamp	C	S101247	-	HB045579

MATERIAL: supplied by DART

DAS
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9-89

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Heather Nixon

Vankleek Hill, April 16, 2020